

Work Order ID 109863

December-03-13 3:03:38 PM

LOAD
B 4986-1
B 109863

109863

Page 1

Item ID: D4936-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 12/03/13 Start Qty: 16.00

16

Cust Item ID:

Required Date: 12/06/13 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4936	A

100	Manufacture as per dwg	0.00
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100

Mill Conv Memo

Conventional Milling Machine

17

DAS
39
9-89

13.12.05

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110

QC Memo

Quality Control

17

DAS
39
9-89

13.12.05

120	QC8- Inspect parts - second check	0.00
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120

QC Memo

Quality Control

DAS
40
9-89

13/12/06

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Item ID: D4936-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp
 Start Date: 12/03/13 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 12/06/13 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130	HandFinish	0.00				17	13-12-9		
	Hand Finishing								
140	QC7-Inspect Chemical Conversion Coat	0.00							DAS
140	QC	0.00				17	13-12-11		34
	Quality Control								9-89
150	Black Sandtex(Ref.4.3.5.7) per QSI005 4.3	0.00							DAS
150	Powdercoat	0.00				17	13-12-11		34
	Powder Coating								9-89

*m 1264 78. START: 11:15
 OVEN T: 300°
 FINISH: 11:45.*

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Item ID: D4936-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp

Start Date: 12/03/13 Start Qty: 16.00

16

Cust Item ID:

Required Date: 12/06/13 Req'd Qty: 16.00

16

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

DAS

27

9-89

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

ST133

0.00

Packaging

DAS
32
9-89

13/12/16

(17)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/12/18

mf
13/12-18

Picklist Print

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Work Order ID: 109863

Parent Item: D4936-1

Parent Item Name: Clamp

Start Date: 12/03/13

Required Date: 12/06/13

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 13-10-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X00.750 6061T6 BAR .375 x .750		Purchased	No				f	13.9990		3			

Location

Loc Qty

Loc Code

MAT049

13.999

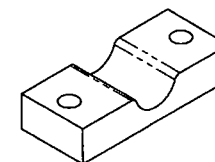
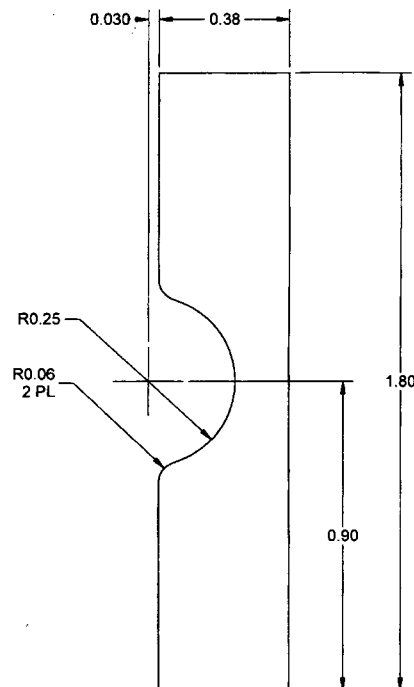
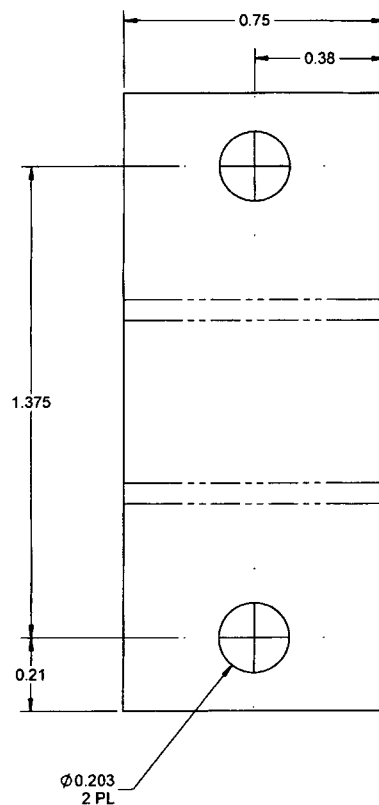
13.999

124029

3.0



13.12.05



W/O 109863

RELEASED
2013-10-30

D4936-1 CLAMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

APPROVED	A	NEW ISSUE	VS	13.09.04
	REV.	DESCRIPTION	BY	DATE
	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	DC	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D4936	SHEET 1 OF 1
	APPROVED	HS	TITLE	SCALE
	DE APPR.	D3	CLAMP	NTS
	DATE	13.10.21	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

